

Date: Tuesday, 19/08/2008 4:07:04 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : UPPER PAD ASSY  
 Job Number : 41505  
 Estimate Number : 13416  
 P.O. Number :  
 This Issue : 19/08/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : PB674300133  
 First Issue : / / Type : SMALL / MED FAB Drawing Number : B6743001 P.41  
 Previous Run : 40294 Drawing Revision : B1  
 Material :  
 Due Date : 18/09/2008 Qty: 20 Um: Each  
 Written By :  
 Checked & Approved By : JUL 08.8.20  
 Comment : Est Rev:A 08-06-20 new issue DD verified by:ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S032 2024-T3 .032 sheet



Comment: Qty.: 0.3217 sf(s)/Unit Total : 6.4344 sf(s)

2024-T3 .032 sheet

batch: 106272x14

HB 8-9-2

108595x

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg B67-43001-325

\*\*\*Use cutting file -325\*\*\*\*\*

Dwg Rev: B1

Prog Rev: B1

HB 8-9-2

(21)

2-Deburr if necessary

HB 8-9-2

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

502/08/02 counted (21)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- counter sink rivet holes as per dwg

CP 08/09/08 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-33 PAR #: N/A Fault Category: Prod / Eng. Ass. med & small NCR: (Yes) No DQA: D Date: 08/10/03  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: D Date: 08/11/03

NCR: <u>41505</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/09/08</u>	<u>5</u>	<u>Found at the countersink 1 piece was side was damaged.</u>	<u>[Signature]</u> <u>08/09/08</u>	<u>Scrap &amp; destroy</u>	<u>08/09/08</u>	<u>[Signature]</u> <u>08/09/08</u>	<u>[Signature]</u> <u>08/09/08</u>	<u>[Signature]</u> <u>08/09/08</u>

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:07:04 PM  
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## Process Sheet

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Drawing Name: UPPER PAD ASSY

Job Number: 41505

Part Number: PB674300133

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/08 (20)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD

08-09-08 (20)

8.0

POWDER COATING

POWDER COATING



M10 2316



(20X)

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

8:50 OF

OVEN TEMPERATURE:

325 OF

FINISH TIME:

9:20

M-P 08/09/13

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P 8/9/15 20

10.0

MS20426AD34

RIVET



Comment: Qty.: 10.0000 Each(s)/Unit Total : 200.0000 Each(s)

RIVET

batch:

M10 5978

LC

11.0

MS21075L3

Nutplate



Comment: Qty.: 5.0000 Each(s)/Unit Total : 100.0000 Each(s)

Nutplate

batch:

M12 9068

LC 8/9/15 (20)

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg B67-43001

EF 08/09/15 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 19/08/2008 4:07:04 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UPPER PAD ASSY

Job Number: 41505

Part Number: PB674300133

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/01/15 (20)

14.0

PG

PURCHASING



Comment: PURCHASING

SEND TO TALMAR FOR FOAM AND FABRIC

C 20/08/09/16 (20)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

P 28/9/22 (20)

16.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 20/09/30 (20)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 510

8/9/30

(20)

30

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/02

Job Completion



MF 08-10-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

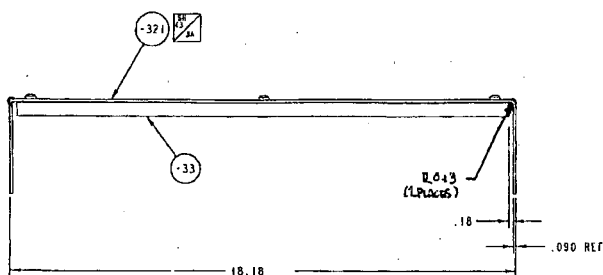
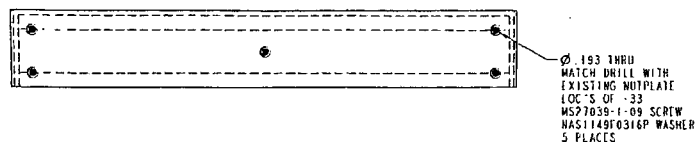
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

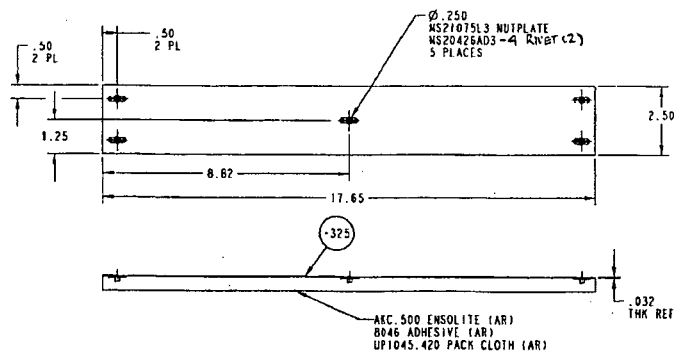
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

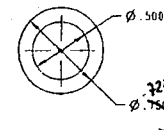
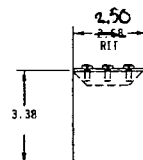
RELEASED  
# 01-20



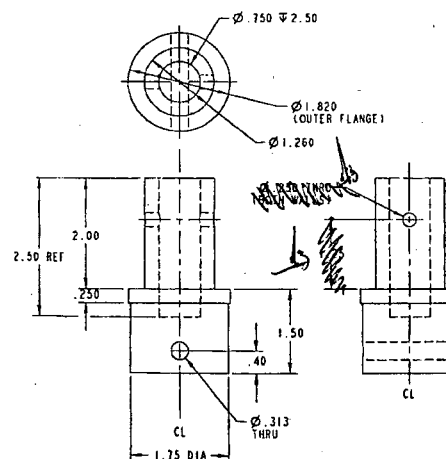
① -31 UPPER RESTRAINT WELDMENT  
SCALE 0.500



① -33 UPPER PAD ASSY  
SCALE 0.500  
MATL FOR -325: .032 THK 2024-T3 AL.  
00-A-250/4



① -299 BUSHING  
SCALE 2.000  
MAT: 304 CRES, COND A



① -305 BEARING  
SCALE 1.000  
MAT: 2024-T3 AL.  
00-A-200/3

PREMIER AVIATION, INC.  
9000 Aviation Parkway, Grand Prairie, Texas 75050  
PART CODE IDENT NO. 000000  
DIOSUV8 B67-43001  
DATE: 01/01/00 BY: 41 OF 45

ORIGINAL

W/AN ORDER  
NO. 41505  
SUBJECT TO AGREEMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHIP COPY

PB 6743001-308

X	First Article	Prototype
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Measured by:	RB	Audited by:	C	Prototype Approval:	A
Date:	8-9-2	Date:	08/09/02	Date:	10





# RELEASE NOTE

# TULMAR

Tulmar Safety Systems Inc.  
1123 Cameron Street  
Hawkesbury, ON K6A 2B8 CA  
Tel: 613-632-1282  
Fax: 613-632-2030  
MID : CATULSAF1123HAW  
www.tulmar.com  
email: info@tulmar.com

Release Note No.

**R92-30213**

Ship Date

26-Sep-08

Bill No:

**Dart Aerospace**

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7. Canada

Ship To:

**Dart Aerospace**

1270 Aberdeen Street

Call: Chantal Lavoie

Tel: 613-632-9577

Hawkesbury, ON K6A 1K7. Canada

613-632-9577

Order No. 21962  
Order Date 16-Sep-08

Customer PO Number  
PO00007171

Item No.  
Description

Customer No. CDART100  
Ship Via  
Pick-Up

Sales Rep. Barney Bangs  
Packing Slip No. 30213

Qty UOM Qty Shipped/Returned Qty Backordered

8421-107 20 EA 20  
Dart Blade Fold Kit - Pad #8/  
Drawing No: (Ref B67-43001-33 Rev B1)  
DWG Rev: NR  
Comments:  
Lot No: BATCH0000000004 Qty: 20

*S*  
*08/09/30*

8421-109 9 EA 9  
Dart Blade Fold Kit - Pad #10/  
Drawing No: (Ref B67-43001-35 Rev B1)  
DWG Rev: A  
Comments:  
Lot No: BATCH0000000004 Qty: 9

8421-104 20 EA 20  
Dart Blade Fold Kit - Pad #5/  
Drawing No: (Ref B67-43001-173 Rev B1)  
DWG Rev: A  
Comments:  
Lot No: BATCH0000000006 Qty: 20

8421-103 20 EA 20  
Dart Blade Fold Kit - Pad #4/  
Drawing No: (Ref B67-43001-181 Rev B1)  
DWG Rev: A  
Comments:  
Lot No: BATCH0000000004 Qty: 20

8421-108 12 EA 12  
Dart Blade Fold Kit - Pad #9/  
Drawing No: (Ref B67-43001-267 Rev B1)  
DWG Rev: NR  
Comments:



# J. ENNIS FABRICS LTD.

*Wholesale Distributor of Textiles and Supplies*

October 20, 2006

**Fax To: Tulmar Safety Systems**  
**Fax: 613-632-2030**  
**Attention: Sandra Nadeau**  
**Fax From: Deanna Penner**

**EDMONTON**  
**HEAD OFFICE**  
12122-68 Street  
Edmonton AB T5B 1R1  
Canada  
Phone: (780) 474-5721

## Certificate of Conformance

**Re: PO 11878 for Oxford 7 Black**

The goods shipped on P/O 11878 are as per sampled goods. Specification as follows:  
As per mill documentation:

**Oxford** is in compliance with the following standards:

**Width:** Product is 58 Inches Wide.

**Roll Size:** Average Roll Length is 75 Yards.

**Weight:** Product Weight is 6.79 Ounces per Sq.Yd. /Product Weight is 10.94 oz per Lin.Yd

**Content:** 100% Nylon

**Coating:** Product has a Polyurethane Coating (approximately 0.65 oz/ Sq.Yd. (18.5g/sq.yd.))

**Denier:** Yarn is 420 Denier.

**Thread Count:** Construction is 62 x 38 Threads per Square Inch

**Protective Finish:** Product is Water Repellent.

**Hydro Resist:** AATCC 127 (Suter): Average 800 mm

**Manufacture Date:** 1) 50 yds each 9/11/06 Piece # 101629822, 101629830, 101629848, 101630226, 101630234, 101630275 & 101630283 &

2) 50 yds each 10/12/06 Piece # 101734465, 101734473, 101734481, 101734499 & 101734507.

**Lot Number:** 1) 50 yds each, #217079 Piece # 101629822, 101629830, 101629848, 101630226, 101630234, 101630275 & 101630283

2) 50 yds each, #221709 Piece # 101734465, 101734473, 101734481, 101734499 & 101734507.

Sincerely,  
**J. Ennis Fabrics Ltd.**

*D. Penner*

Deanna Penner  
Product Development

English: 1-800-66-ENNIS

Fax: (780) 479-6135  
[www.jennisfabrics.com](http://www.jennisfabrics.com)

Français: 1-888-66-ENNIS

**CALGARY**  
2nd Floor 337-17 Avenue SW  
Calgary AB T2S 0A5  
Canada

**VANCOUVER**  
13911 Bridgeport Road  
Richmond BC V6V 1J6  
Canada

2

# 11155 / 11

# RELEASE NOTE

# TULMAR

Tulmar Safety Systems Inc.  
1123 Cameron Street  
Hawkesbury, ON K6A 2B8 CA  
Tel: 613-632-1282  
Fax: 613-632-2030  
MID: CATULSAF1123HAW  
www.tulmar.com  
Email: info@tulmar.com

Release Note No.

**R92-30213**

Ship Date

26-Sep-08

B/N No:

**Dart Aerospace**

1170 Aberdeen Street  
Hawkesbury, ON K6A 1K7. Canada

Ship To:

**Dart Aerospace**

1270 Aberdeen Street  
Call: Chantal Lavoie  
Tel: 613-632-9577  
Hawkesbury, ON K6A 1K7. Canada  
613-632-9577

**Order No.**

21962

**Order Date**

16-Sep-08

**Customer PO Number**

PO00007171

**Item No.**

**Description**

Lot No: BATCH0000000003 Qty: 12

**Customer No.**

CDART100

**Ship Via**

Pick-Up

**Qty**

**UOM**

**Qty Shipped/Returned**

**Qty Backordered**

**Sales Rep.**

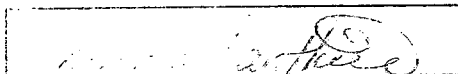
Barney Bangs

**Packing Slip No.**

30213

If any questions or concerns, please contact QA Manager @ 613-632-1282 ext. 245.

This release note is a Certificate of Conformance and I hereby certify that the items listed hereon have been inspected, tested and conform to all specifications and requirements detailed in the contract or purchase order. Objective evidence to support this release note is on file, and can be made available upon request.



Authorized Inspector

09/26/2008

Date